

Work Order ID 116965

April-24-14 8:46:18 AM

116965

Page 1

Item ID: D500-560-041

Revision ID:

Item Name: Cargo Mirror Installation

Start Date: 4/23/14

Start Qty: 2.00

2

Required Date: 4/23/14

Req'd Qty: 2.00

2

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MCS

Date: 14-04-28

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev D

MCS 14-04-30

100

Document Control

DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D500-560-041 CHG006

DAS
31
9-89

Ha

14-05-05

110

Small Fab

0.00

110

Small Fab

Memo

0.00

Small Fab

Before assembly repass tap on stud.
Assemble as per drawing D500-560
PAGE 8- BLUE FILE

DAS
27

0.00 9-89

14/4/29

4

FF 14-04-29

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 116965

April-24-14 8:46:18 AM

116965

Page 2

Item ID: D500-560-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Mirror Installation

Start Date: 4/23/14 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	Pick Kit	0.00							DAS 32 9-89
-----	----------	------	--	--	--	--	--	--	-------------------

130

Packaging Memo

Packaging

140	QC4- 100% Inspect kits for completeness	0.00							DAS 31 9-89
-----	---	------	--	--	--	--	--	--	-------------------

140

QC Memo

Quality Control

150	Packaging	0.00							DAS 06 9-89
-----	-----------	------	--	--	--	--	--	--	-------------------

150

Packaging Memo

Packaging

Identify and pack for shipping as per PPP D500-560-041

Location: Out

PPP Rev: _____

MAY 05 2014

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

April-24-14 8:46:20 AM

Page 1

Work Order ID: 116965

116965

Parent Item: D500-560-041

D500-560-041

Parent Item Name: Cargo Mirror Installation

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E03.10.15Reformat; Removed D2057KJ/RF
IPP Rev:F 08-05-27 as per ECN1195p DD verified by:EC IPP Rev:G
10.04.22 chg route seq DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R10 Purchased No

AN526C1032R10

Screw

Location	Loc Qty	Loc Code
FP001	22	
108062	22	
ST505	133	
m128712	133	

D1048 Manufactured No

D1048

Clamp

Location	Loc Qty	Loc Code
GA	34	
115372	34	
	18.0000	

D1049 Manufactured No

D1049

Saddle

Location	Loc Qty	Loc Code
GA	18	
108735	2	
115511	16	

**

FF 14-04-29

**

FF 14-04-29

**

FF 14-04-29

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 116965

116965

Parent Item: D500-560-041

D500-560-041

Parent Item Name: Cargo Mirror Installation

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 2.007

Required Qty: 2.00

D2010-101 Manufactured No

110 Each 10.0000 1 24

D2010-101

**

FF 14-04-29

Mirror Bracket 369/500

Location

Loc Qty

Loc Code

ST220

10

105122

10

D2010-103 Manufactured No

110 Each 7.0000 1 24

D2010-103

**

FF 14-04-29

Mirror Arm 369/500

Location

Loc Qty

Loc Code

ST220

7

104979

7

D2011-101 Manufactured No

110 Each 13.0000 1 24

D2011-101

**

FF 14-04-29

Mirror 6"

Location

Loc Qty

Loc Code

FG

2

106348

2

ST179

11

113569

11

AN3-4A Purchased No

140 Each 412.0000 4 816

AN3-4A

**

m128735

DAS
32
9-89

Bolt

Location

Loc Qty

Loc Code

ST350

364

m128429

100

m128739

264

ST511

48

m127044

48

DAS
31
9-89

14/4/30
(4)

April-24-14 8:46:20 AM

Shop Packet Print

Page 2

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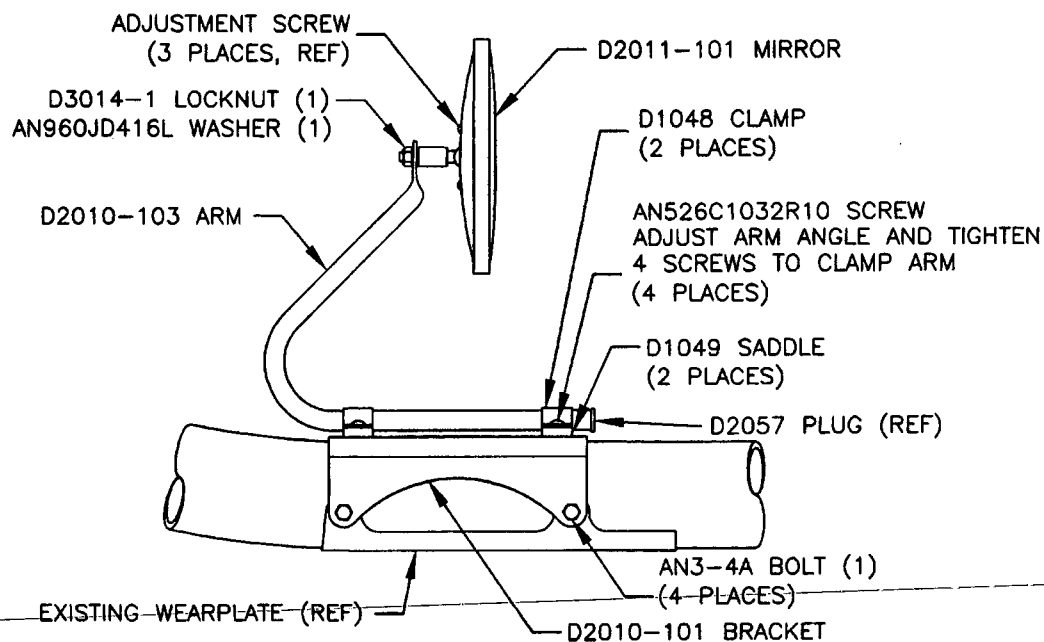


Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041 Cargo Mirror Assembly	1.0 lb 0.45 kg	-45 in -1.14 m	-45 lb-kg -0.51 m-kg	24 in 0.61 m	24 in-lb 0.27 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT
4	AN526C1032R10	SCREW (OR AN526-1032R10)

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

116965
1404-28
57N 596911

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Revision: D

Date: 01.04.24